

Date: Monday, 11/21/2005 11:55:18 AM
 User: Linda Lacle

Process Sheet

SLPIT-2

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RADIUS BLOCK		
Job Number	: 24872		Part Number	: D2274		
Estimate Number	: 10822		Drawing Number	: D2274 REV F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/21/2005 S.O. No. : N/A		Drawing Revision	: F		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/15/2005 Qty: 500 Um: Each		
Previous Run	: N/A					
Written By	: See comment below					
Checked & Approved By	: See comment below					
Comment	: Est. H 00.05.18 Added inspection level 8 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"	
		Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s) 6061-T6 Bar .75" x .125" Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch 117599	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274	EP 05/12/06 539
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	EP 05/12/06 539
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	M 05/12/06 539
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling	DC 05/12/12 472

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 24872

Part Number: D2274

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	DL 05/12/14 472
7.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	ML 05/12/14 472
8.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 35	105/12/14 472
9.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	DP 05/12/15 472

Job Completion



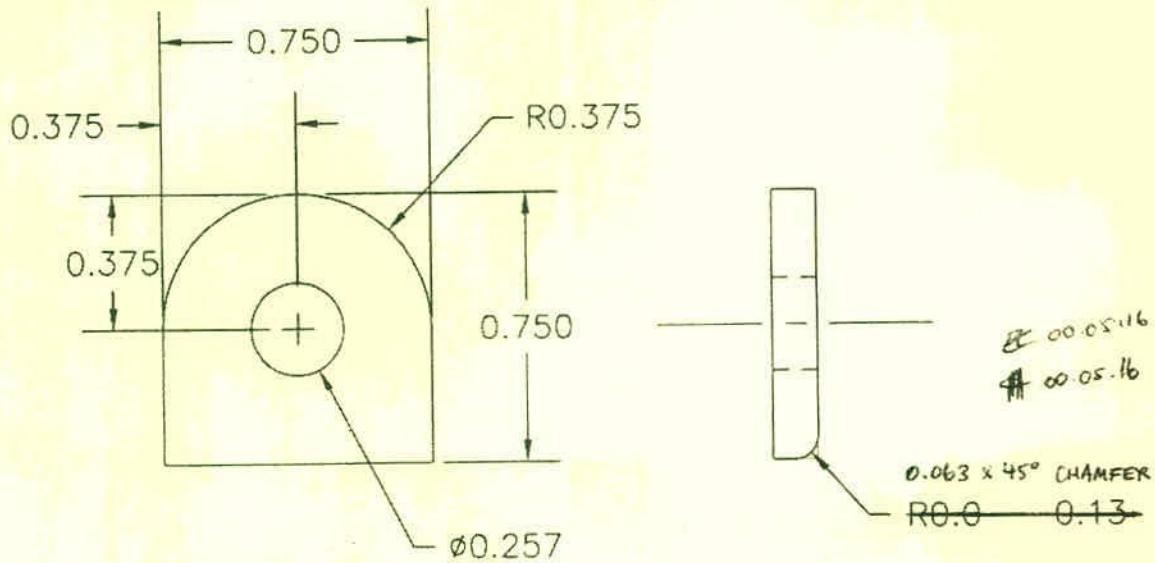
SL 05/12/14

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED NO	APPROVED GS	DRAWING NO. D2274
DATE 98.08.11		REV. F SHEET 1 OF 1 TITLE RADIUS BLOCK SCALE 2:1

RELEASED

18/08/98 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order:	
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: BG	Audited by: SD	Prototype Approval: NA
Date: 05.12.05	Date: 05.12.05	Date: NA

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	

